

Date: Tuesday, 1/8/2008 1:19:30 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HANDLE WELDMENT		
Job Number	36657			Part Number	D2530		
Estimate Number	10333			Drawing Number	D2530 REV B		
P.O. Number				Project Number	N/A		
This Issue	1/8/2008	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	2/5/2008		
Previous Run	35357			Qty:	20*		
Written By	<i>10</i> 08.01.08			Um:	Each		
Checked & Approved By				23			
Comment	Est Rev.E	Removed Purchasing	05-11-07	JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
	Comment: Qty.: 3.0602 f(s)/Unit Total : 61.2045 f(s) Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049) Batch: M106015	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Cut to length as per Dwg D2536 2-Deburr	<i>+6/1m 08/01/21</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP
		 <i>✓ 08/01/21 (423)</i>
	Comment: INSPECT WORK TO CURRENT STEP	
4.0	D2534	Lock Plate
		 <i>FC 08/01/21 (23)</i>
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: QTY Part # Description Batch 2 D2534 Lock Plate 53662 (416)	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <i>FC 08/01/21 (23)</i>
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301 2-Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-02-21 (23)

7.0 QC5

INSPECT WORK TO CURRENT STEP



J 08-02-20 (20)



PTO

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



11100700

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

08/02/22

ACK

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 204

8h122

5d

20x

(20)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/22

Job Completion



m-2008(2/22)

20

U

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-02-21	S.O	8 part scrap. ends are not square, and do not sit flat. R.C.: Pulled when welded, Human error.	J	Scrap = destroy. No replace.	08/02/21	/	08-02-21 08/02/21	/

NOTE: Date & initial all entries

DART

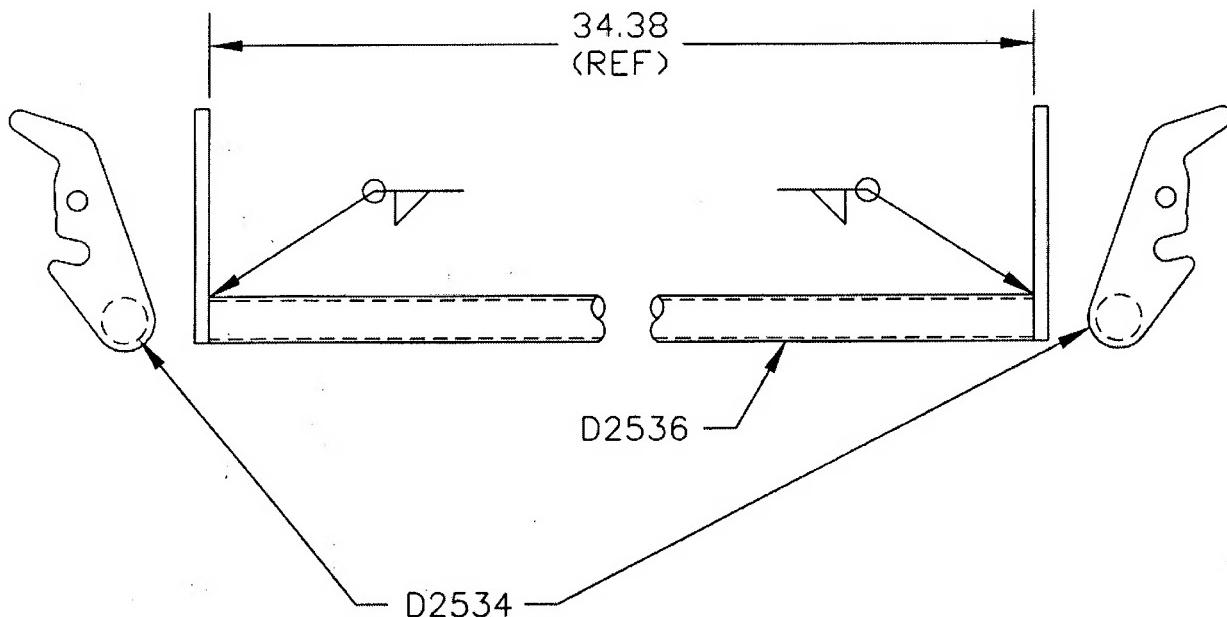
DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530
DATE 04.12.14	TITLE	REV. B SHEET 1 OF 1
A	96.06.18	SCALE NEW ISSUE
B	04.12.14	UPDATE NOTES AND DIMENSIONS

RELEASED

04.12.16 *[Signature]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *36657*